



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4575-1

Job Sheet 200172



Part No: D4575-1

Job Qty: 4 pcs

DAS
21
9-88

Part Name: Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A 12.01.12 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		10/7/19	0.17	0.32	Waterjet - Flow		02/19/10/05
120	QC 8	4 pcs		10/7/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	4 pcs		10/7/19	0.25	0.33	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 -		

DAS
40
9-88

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https://www.plexonline.com/b25881ee-b58c-4ea8-8f8b-5d1158a3d724/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 2/4

					QC 3 - 40	OCT 16 2019	
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
170 Packaging 3-1 - Stock - B4B	5	4	pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	ST 259
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B ✓	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
180 QC 21 - SA	5	4	pcs	10/7/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 259 DAS 21 9-9 OCT 18 2019
						QC 21 - SA - 70	
						QC 21 - SA - 53	

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Bend/Assemble as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.2120 sf (.553 ea)	100-Waterjet - Flow - 1	SV55269

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.050	2	46	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Beam	2.800Inches ± 0.010	2.810 2.790		
2	Beam	3.750Inches ± 0.010	3.760 3.740		
3	Beam	4.190Inches ± 0.030	4.220 4.160		
4	Beam	0.625Inches ± 0.010	0.635 0.615		
5	Beam	7.650Inches ± 0.030	7.680 7.620		
6	Beam	16.900Inches ± 0.030	16.930 16.870		
7	Beam	19.000Inches ± 0.030	19.030 18.970		
8	Beam	0.050Inches ± 0.010	0.060 0.040		

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Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS							
Part No. _____		Rework Scrap Use-as-is		Eng. (Non-AW) Prod. Eng. Coord. Rec./Store/Packaging							
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation		Disposition									
				Completed By							
				Lead hand / Supervisor							
				QC / QA Coordinator							
Root Cause		FAULT CATEGORY									
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong			
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance			
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing			
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish			
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing			
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread			
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up					
Human Factors		Other/Details:									